

Work Order ID 48626

June 26, 2009 12:07:42 PM



PRELIMINARY ISSUE

Item ID: D3849-041
 Revision ID: PRELIMINARY
 Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 2.00



Required Date: 03/08/2009 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3849

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control



Date: Wednesday, 17/06/2009 10:49:58 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD WEARPLATE ASS'Y, STD/FLOAT GEAR
Job Number	: 48626		
Estimate Number	: 13893		
P.O. Number	:	Part Number	: D3849041
This Issue	: 17/06/2009 S.O. No. :	Drawing Number	: D3849 PREL <i>Rev. B</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: PREL
Previous Run	: 47810	Material	:
Written By	:	Due Date	: 24/06/2009
Checked & Approved By	: <i>MF 09-06-17</i>	Qty:	<i>split 1</i> 2 Um: Each
Comment	: Est Rev:A 09.04.29 new issue EC verified by:DD		

Additional Product



Job Number:



PRELIMINARY ISSUE

Seq. #: Machine Or Operation:

Description:

1.0 M304S18GA

304/316 .050 Sheet



Comment: Qty.: 2.4500 sf(s)/Unit Total: 4.9000 sf(s)
 304/316 .050 Sheet
 batch: *111743* *IB 9-6-19*

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3849
 Dwg Rev: *PREL*
 Prog Rev: *Linn*

*IB 9-6-19**(2)*

2-Deburr if necessary

IB 9-6-19

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-6-19

4.0

QC8

ENGINEERING APPROVAL

SECOND CHECK



Comment: SECOND CHECK

*09-06-19 (2)**RA 09.07.02**(PC)*

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per dwg using DT8179 & DT8155


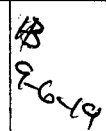
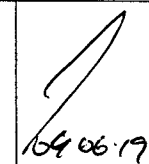
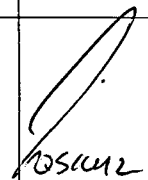
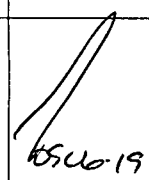
*SB 09/06/19**(2)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3849-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>48626</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
090619	20	Diff: W. Jet program was not updated i Rev. A were made Qty 2 RC: Lack of Attention Prod. Eng.	 090619	Scraps destroy Qty 2 Replace Rev. B	 26-19	 06-19	 090619	 090619

NOTE: Date & initial all entries

Date: Wednesday, 17/06/2009 10:49:58 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD WEARPLATE ASS'Y, STD/FLOAT GEAR

Job Number: 48626

Part Number: D3849041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**



09-09-02

7.0

D39011

Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bar

batch: B47817

02 7-6-10

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1



1- On D3901-1 bar, fill cut outs with hardcoat welding rod as per dwg D3849

2059 B Hardcoat Welding Rod

BATCH#: M106681

2- Weld D3901-1 bar to wearplate by positioning holes together as per dwg D3849

304 S.S. Welding Rod

BATCH #: M102421

02 7-6-08

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION



09-06-22

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



09-06-22

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3



START TIME: 9:15 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:45 AM

09-06-22

02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 17/06/2009 10:49:58 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD WEARPLATE ASS'Y, STD/FLOAT GEAR

Job Number: 48626

Part Number: D3849041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-06-22 (2)

13.0

D38481

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gasket

batch:

B48643

SB 09/06/22 (2)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bond D3848-1 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg

BATCH:

M111428

SB 09/06/22 (2)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PA 09.07.01
**ENGINEERING
APPROVAL**

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location:

STORE IN ENG'G
ENG USE ONLY
PA 09.09.02

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE

RELEASED

AUTH

DATE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DATE: Wednesday, 17/06/2009 10:49:59 AM
 USER: Melanie Faulstich

Process Sheet

Customer : DU-DAR001 Dart Helicopters Services Drawing Name : FWD WEARPLATE ASSY, STD/FLOAT GEAR
 Job Number : 48628
 Estimate Number : 13693
 P.O. Number :
 This Issue : 17/06/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : LARGE FAB ASSY
 Previous Run : 47810
 Written By :
 Checked & Approved By : MF 09-06-17
 Comment : Est Rev:A 09.04.29 new issue EC verified by:DD

Part Number : D3849041
 Drawing Number : D3849 PREL *Rev S*
 Project Number : N/A
 Drawing Revision : PREL
 Material :
 Due Date : 24/06/2009 Qty: *Split 1.* 12 Um: Eac

Additional Product



Job Number:



PRELIMINARY ISSUE

Seq. #:

Machine Or Operation:

Description:

1.0

M304S18GA

304/316 .050 Sheet



Comment: Qty.: 2.4500 sf(s)/Unit Total: 4.9000 sf(s)

304/316 .050 Sheet

batch: 111743 *IB 9-6-19*

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3849

Dwg Rev: PEFLProg Rev: Liam*IB 9-6-19**(2)*

2-Deburr if necessary

IB 9-6-19

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-6-19

4.0

QC8

ENGINEERING APPROVAL



Comment: SECOND CHECK

*09-06-19 (2)**PTC*

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per dwg using DT8179 & DT8155

SB 09/06/19

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD WEARPLATE ASS'Y, STD/FLOAT GEAR

Job Number: 48626

Part Number: D3849041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

7.0

D39011

Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bar

batch: B47817

EZ 7-6-10

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- On D3901-1 bar, fill cut outs with hardcoat welding rod as per dwg D3849

2059 B Hardcoat Welding Rod

BATCH#: M102681

2- Weld D3901-1 bar to wearplate by positioning holes together as per dwg D3849

304 S.S. Welding Rod

BATCH #: M102421

EZ 7-6-28

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-06-22

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-06-22

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 9:15 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:45 AM

09-06-22

(2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD WEARPLATE ASS'Y, STD/FLOAT GEAR

Job Number: 48626

Job Number:

Part Number: D3849041

Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

D38481

Gasket

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Gasket

batch: B48643

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bond D3848-1 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip
adhesive as per dwg

BATCH: M111420

15.0

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

16.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock
Location:

17.0

QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

POSITIVE RECALL
EFFECTIVE AUTH
RELEASED DATE

DART AEROSPACE LTD		Work Order: 48626
Description: FWD WFAIR PLATE ASSY STD/FLOAT GEAR		Part Number: D3849-1
Inspection Dwg: D3849-1 Rev: PRE LIM		Page 1 of 1

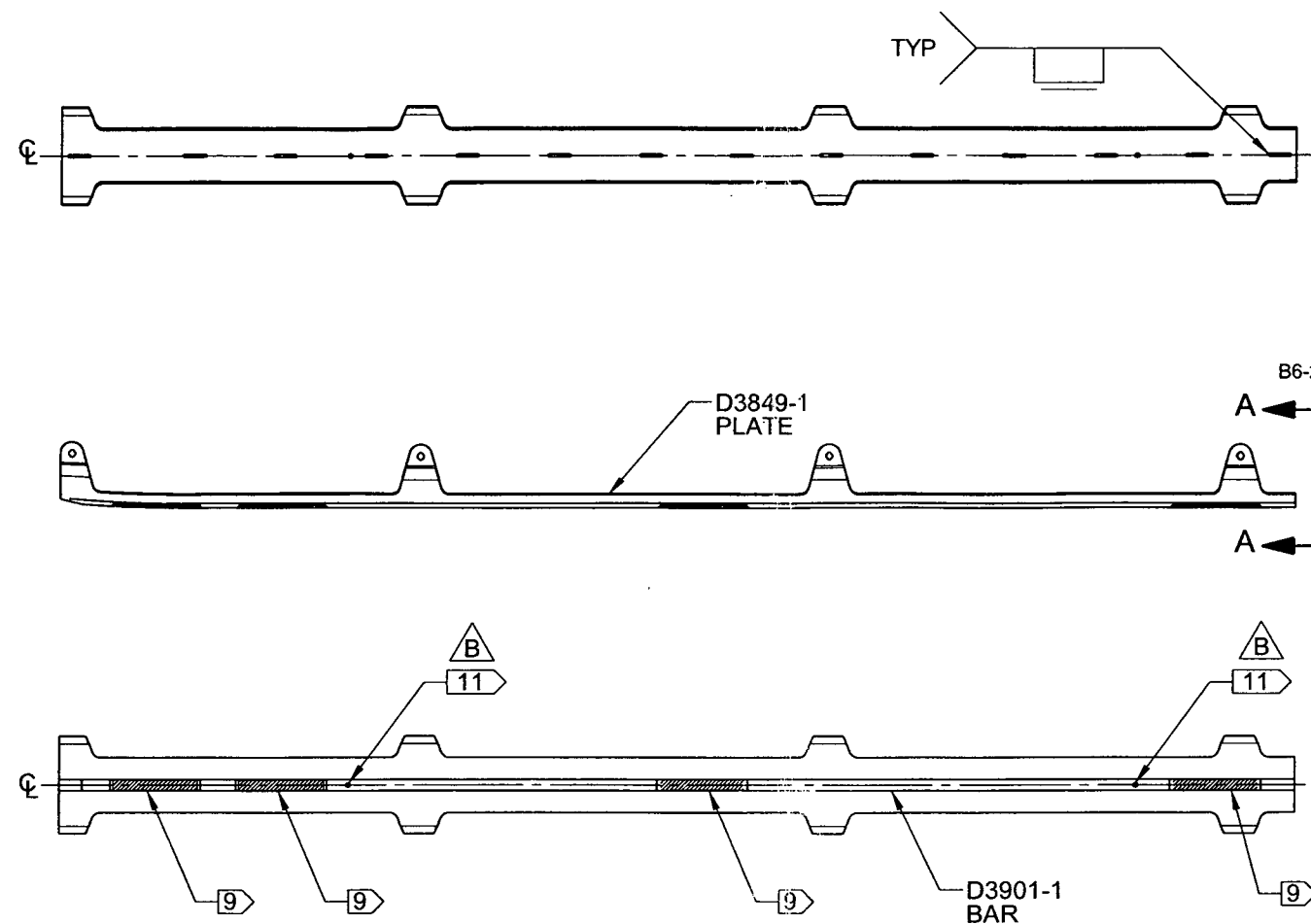
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+ .005 - .001	.190	X			
.300	± .010	.303	X			
.350	± .010	.354	X			
.88	± .030	.884	X			
.25	± .030	.259	X			
.125	± .010	.129	X			
2.433	± .016	2.439	X			
6.642	± .010	6.645	X			
2.45	± .036	2.451	X			
4.38	± .036	4.381	X			
7.00	± .036	7.004	X			
4.00	± .030	4.002	X			
34.500	± .010	34.500	X			
54.26	± .030	54.250	X			
5.89	± .030	5.893	X			
51.313	± .016	51.313	X			
36.000	± .010	36.000	X			
18.000	± .010	18.000	X			
7.69	± .030	7.697	X			
1.050	± .016	1.048	X			

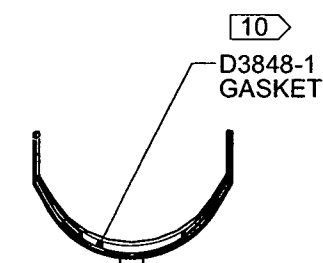
Measured by: RB	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 9-6-19	Date: 9-6-19	Date: 09-09-09

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3849-041 FWD WEARPLATE ASSY, STD/FLOAT GEAR

**PRELIMINARY
ISSUE** 09 06-16



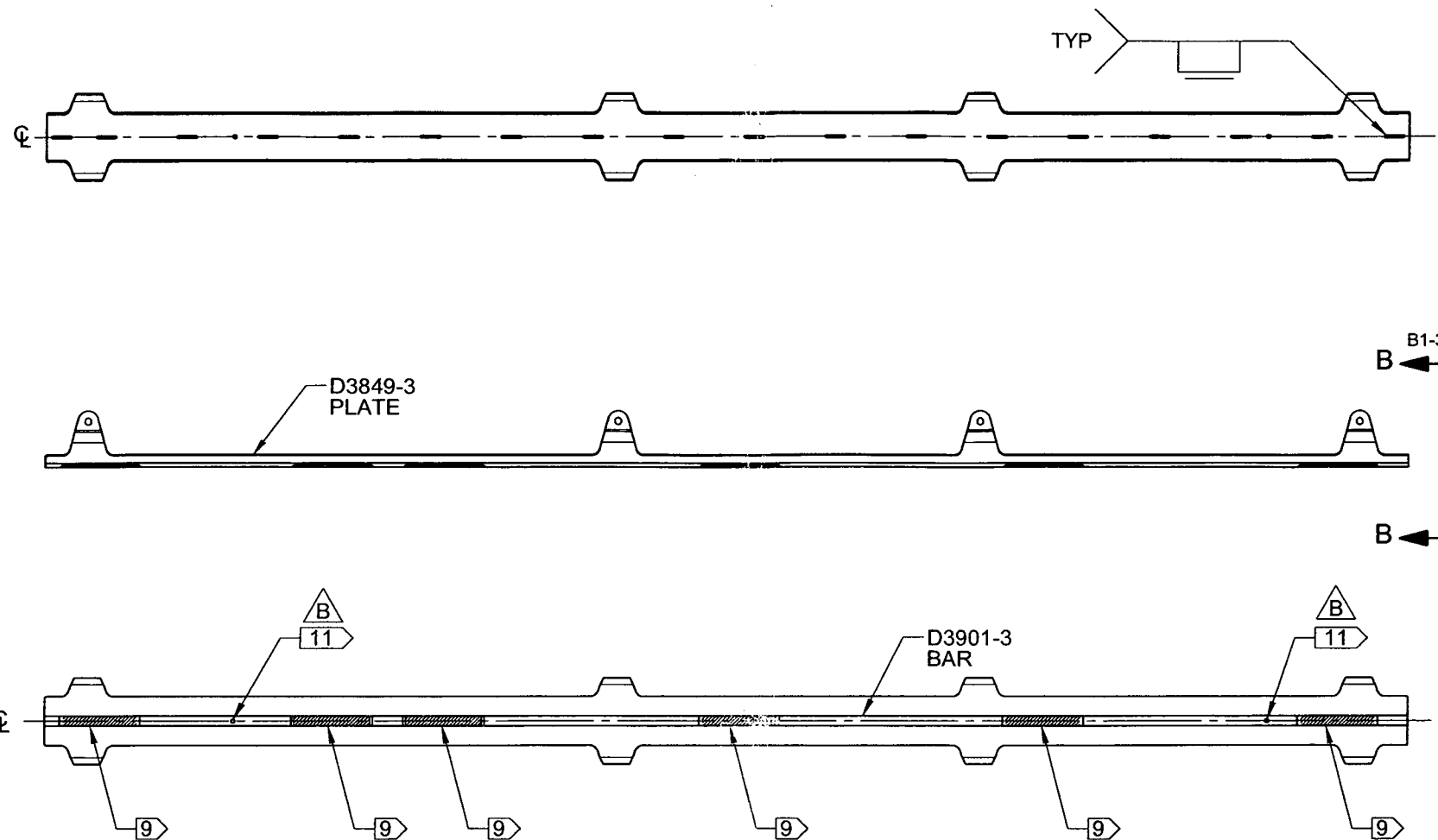
SECTION A-A C2-2
SCALE 2X

PRELIMINARY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-041" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-041 = 4.24 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-1 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-1 PLATE TO D3901-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO. D3849	REV. B
MFG. APPR.			SHEET 2 OF 8
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.		<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DATE	09.06.16		



**PRELIMINARY
ISSUE** *09.06.16*

D3849-043 AFT WEARPLATE ASSY, STD GEAR

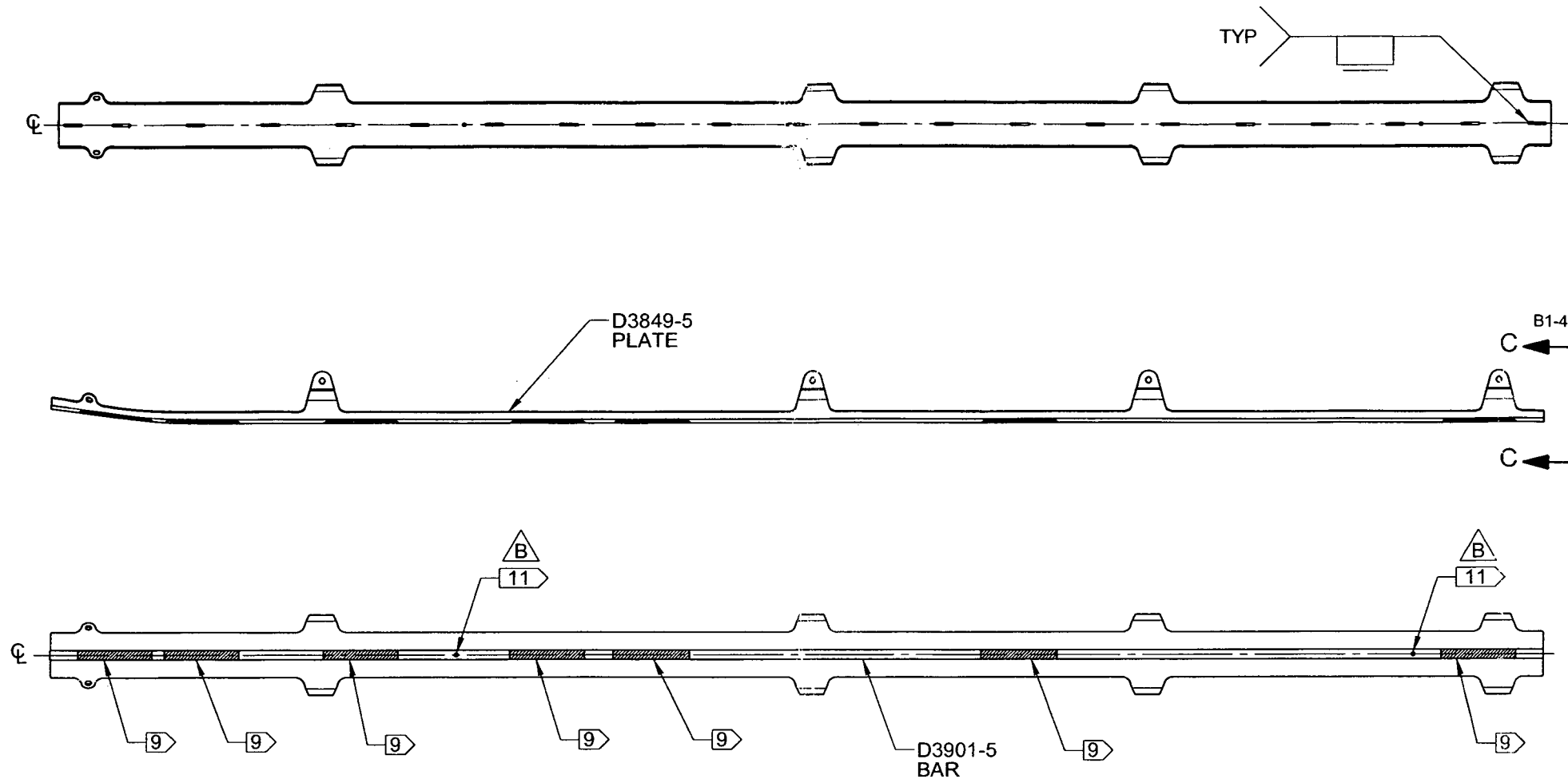
SECTION B-B C2-3
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3849-043 = 5.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-3 PLATE TO D3901-3 BAR

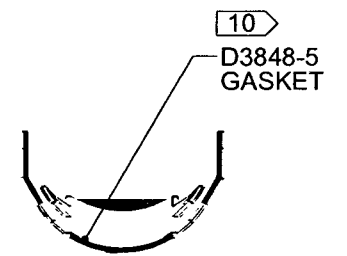
PRELIMINARY

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE 09.06.16		COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR

**PRELIMINARY
ISSUE** 09.06.16



SECTION C-C C2-4
SCALE 2X

PRELIMINARY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-045 = 5.98 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-5 PLATE TO D3901-5 BAR

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO. D3849	REV. B
MFG. APPR.			SHEET 4 OF 8
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.		DATE 09.06.16	
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8

7

6

5

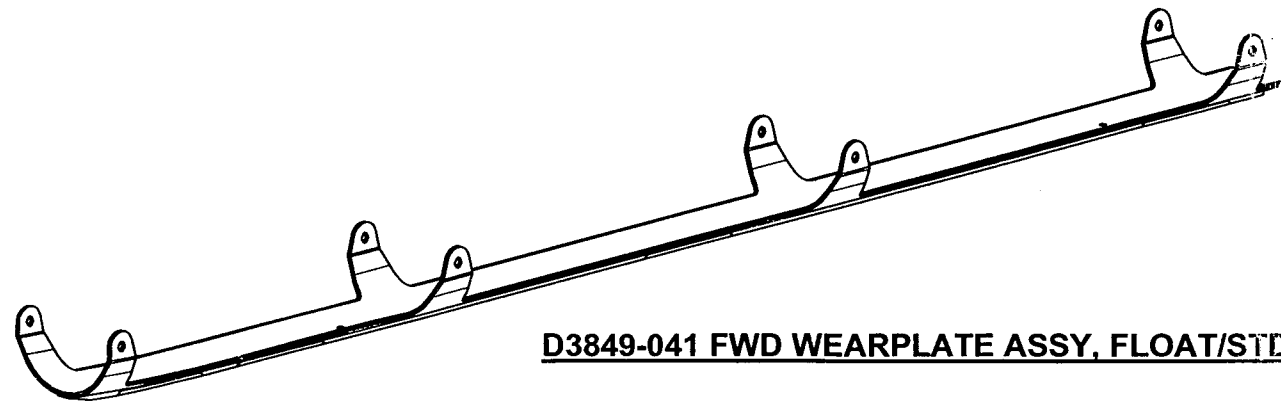
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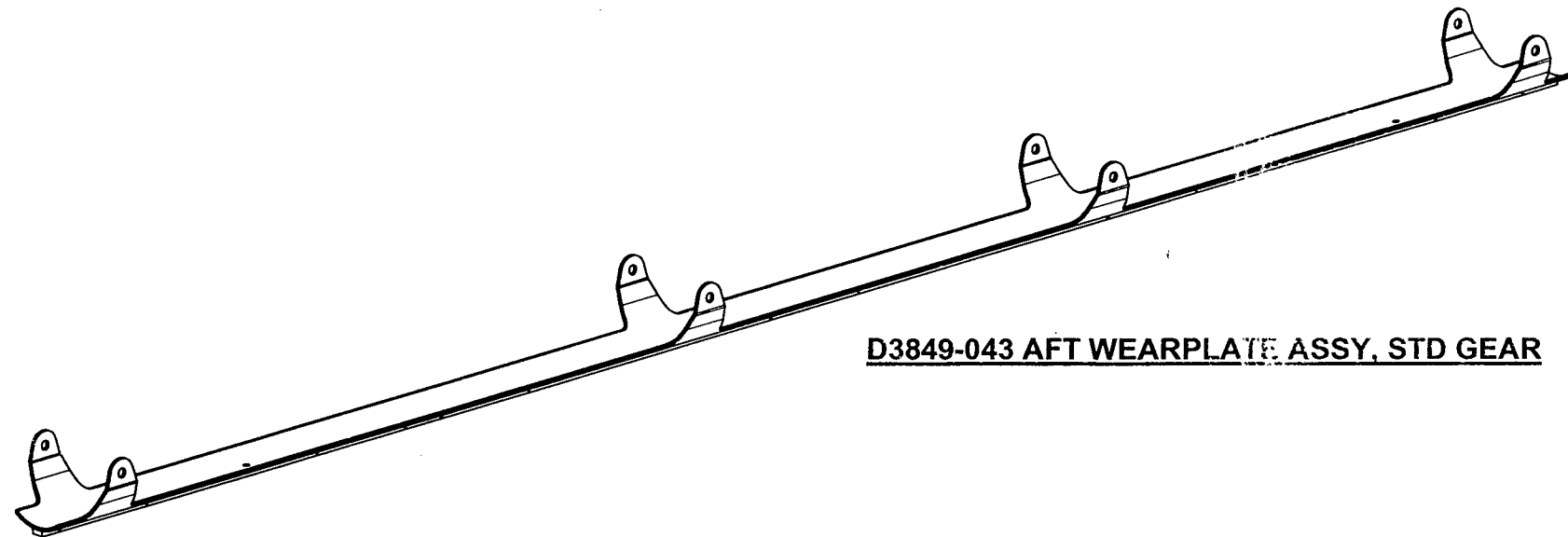
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1

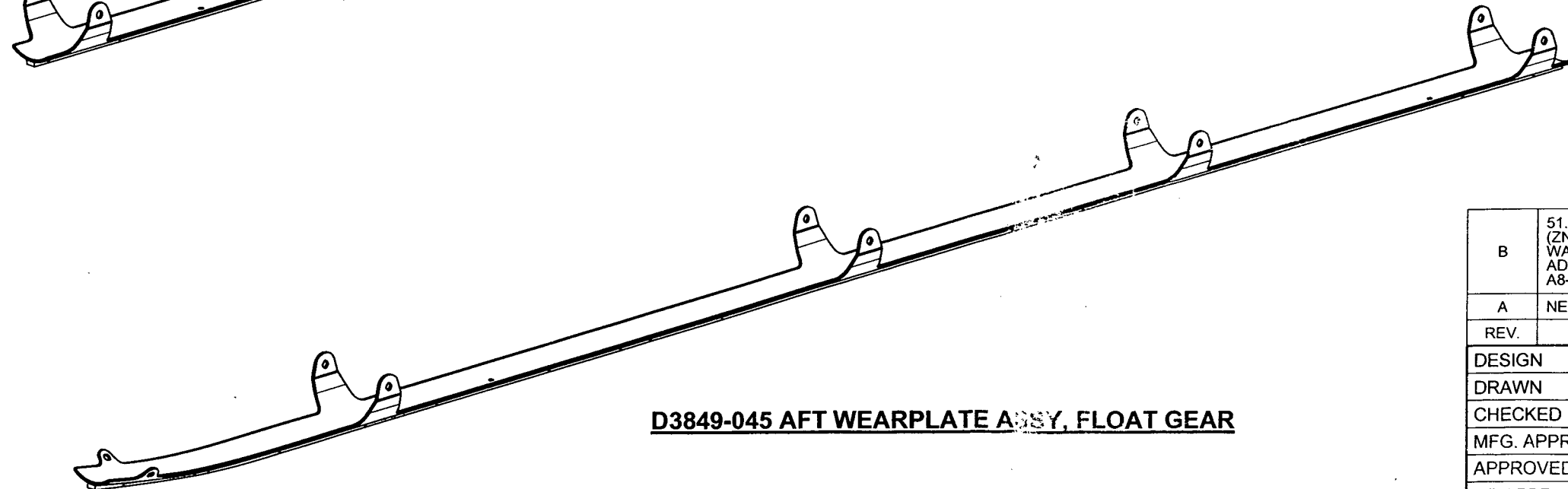
ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3849-041	FWD WEARPLATE ASSY, STD/FLOAT GEAR
2		X		D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X	D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
11	1			D3849-1	PLATE
12		1		D3849-3	PLATE
13			1	D3849-5	PLATE
14	1			D3848-1	GASKET
15		1		D3848-3	GASKET
16			1	D3848-5	GASKET
17	1			D3901-1	BAR
18		1		D3901-3	BAR
19			1	D3901-5	BAR
31	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE



D3849-041 FWD WEARPLATE ASSY, FLOAT/STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR

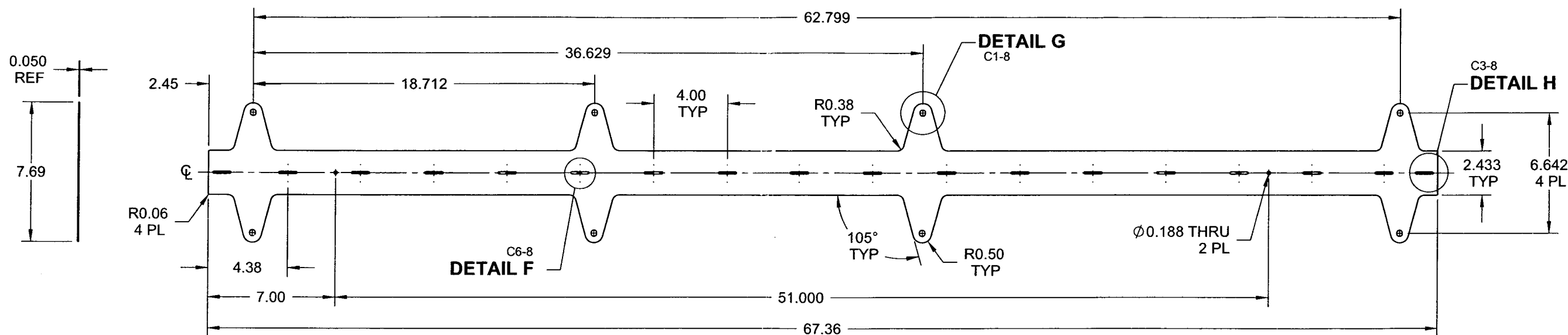
**PRELIMINARY
ISSUE** *09.06.16*

PRELIMINARY

B	51.313 WAS 51.213 (ZN C4-5); 6.642 4 PL WAS 6.642 2 PL (ZN B1-5); 7.69 WAS 7.84 (ZN B8-5); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN D6-8); ADDED 0.25 & ADDED 0.44 (ZN D4-8); ADDED FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4)	RF	09.06.16
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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D3849-3 PLATE
(MAKE FROM D3849-3F)

E
E
A6-8



D3849-3F FLAT PATTERN

**PRELIMINARY
ISSUE** *09.06.16*

PRELIMINARY

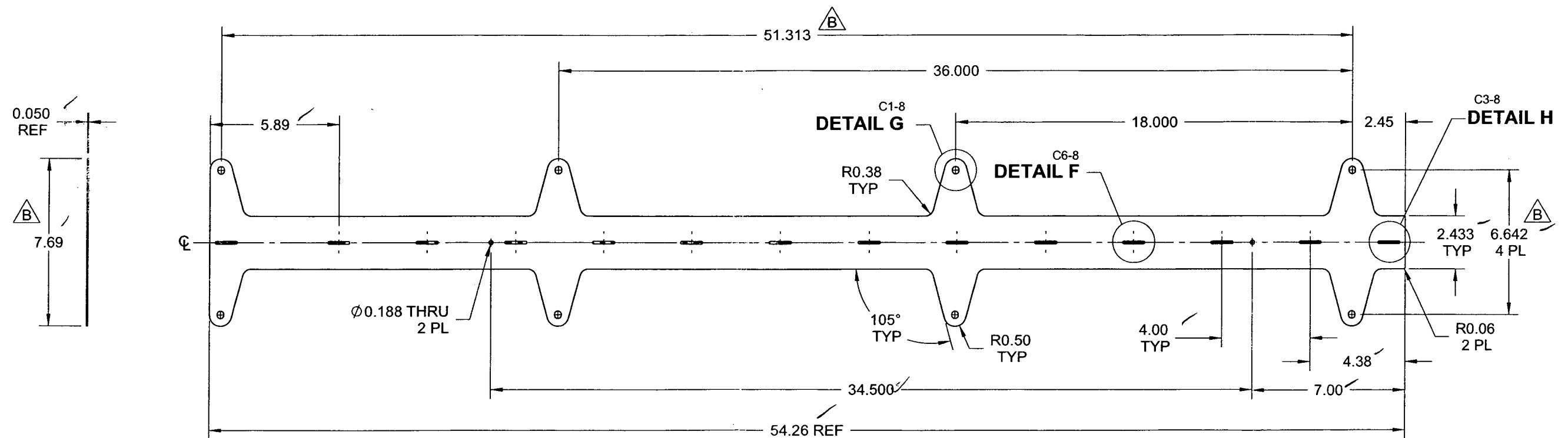
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.82 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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D3849-1 PLATE
(MAKE FROM D3849-1F)



D3849-1F FLAT PATTERN

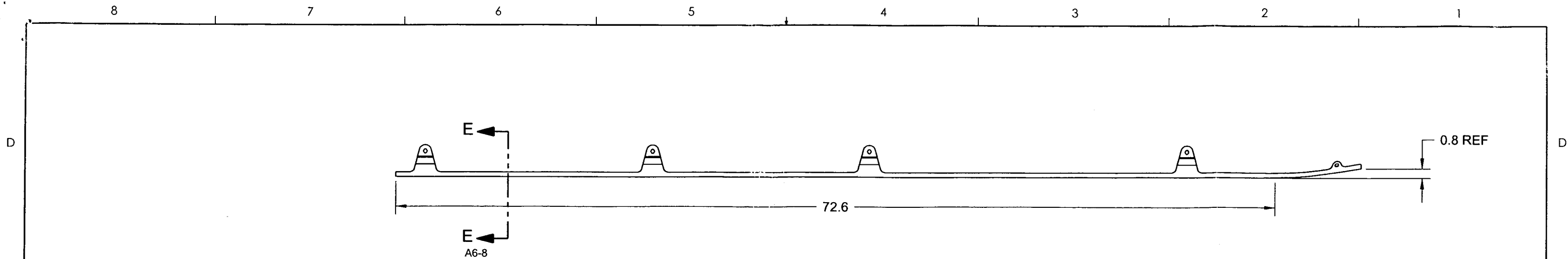
**PRELIMINARY
ISSUE** *09.06.16*

PRELIMINARY

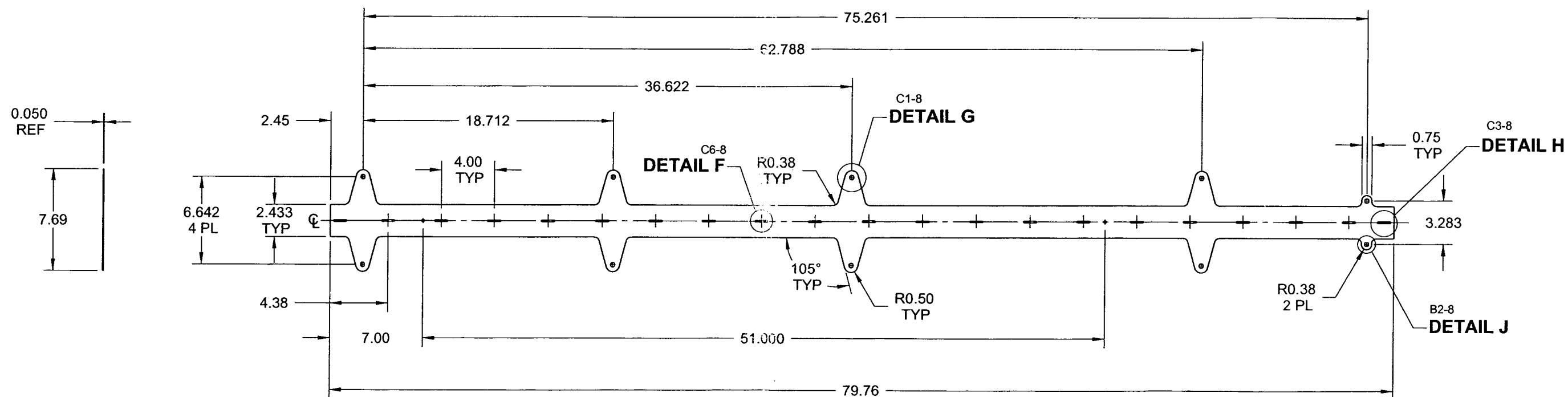
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.3 lbs

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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D3849-5 PLATE
(MAKE FROM D3849-5F)



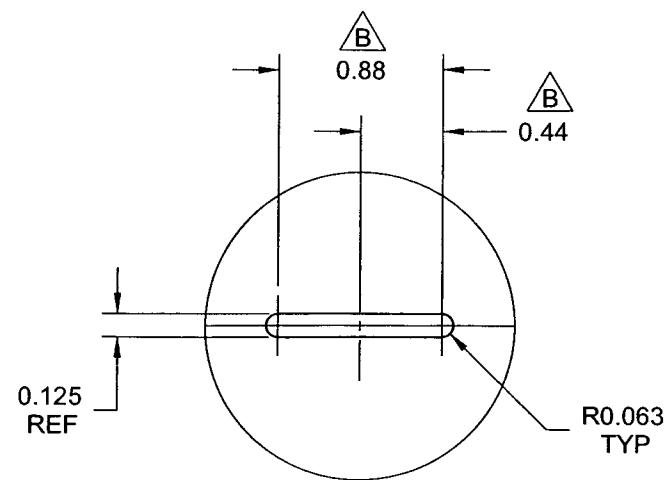
D3849-5F FLAT PATTERN

PRELIMINARY
ISSUE 09.06.16

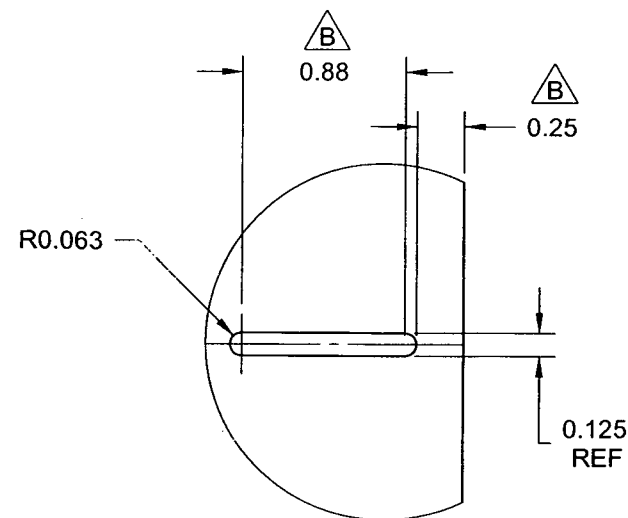
PRELIMINARY

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 3.30 lbs

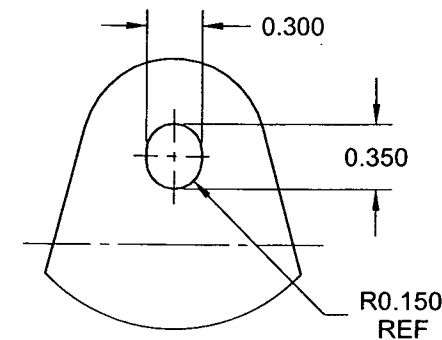
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 7 OF 8
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DE APPR.		WEARPLATE ASSY	NTS
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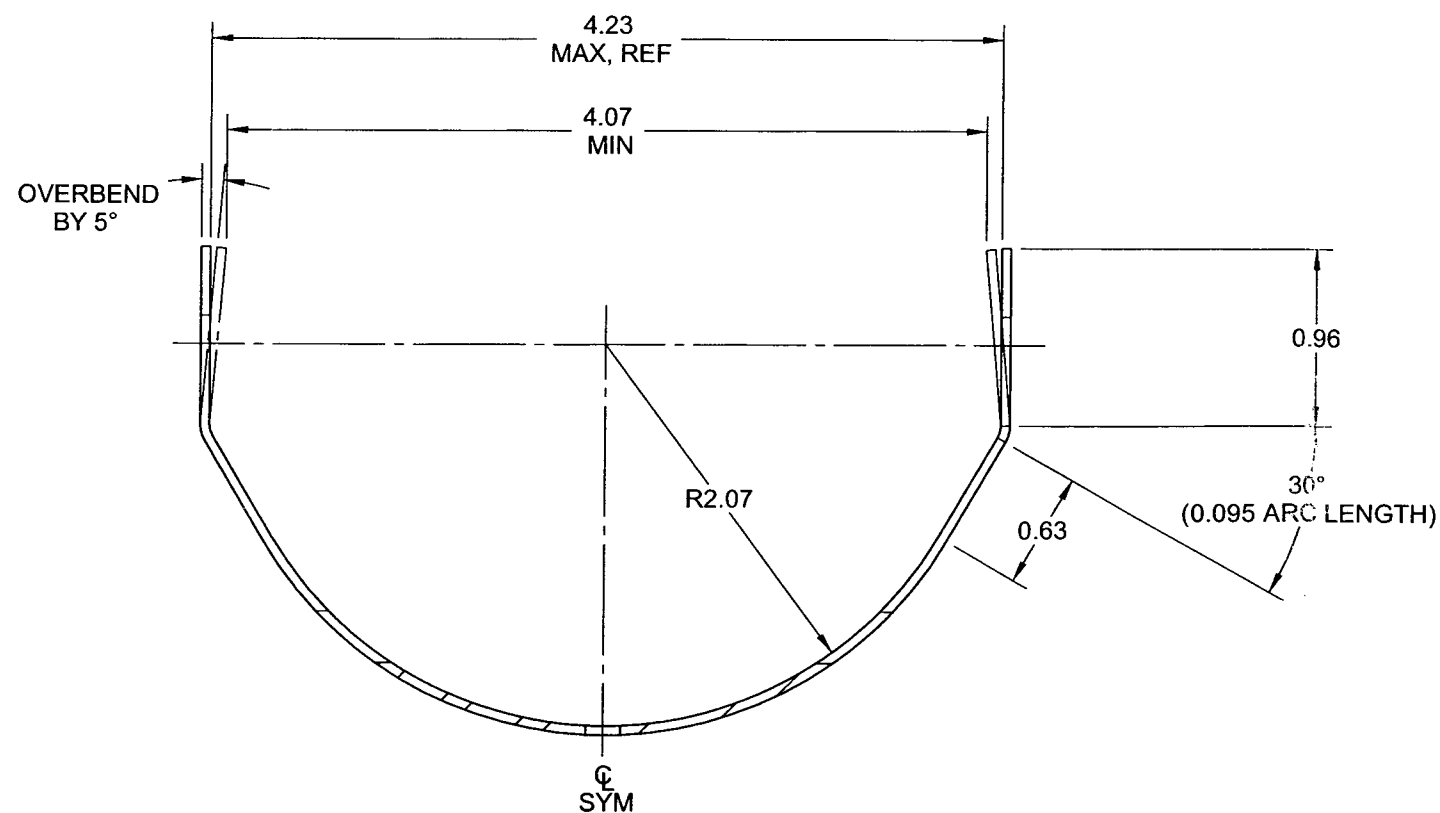
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C3-5
B6-6
C3-7



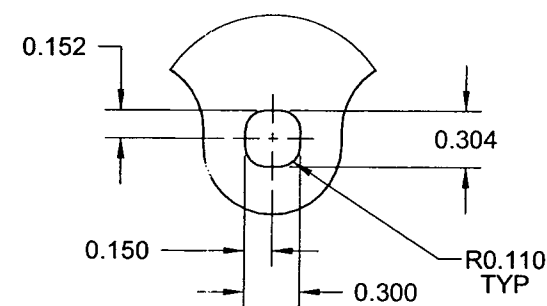
DETAIL H
SLOT DETAIL TYP
SCALE 4X
C1-5
C1-6
C1-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C4-5
C3-6
C4-7



SECTION E-E
SCALE 4X
D2-5
D2-6
D6-7



DETAIL J
DETAIL TYP
SCALE 8X
B1-7

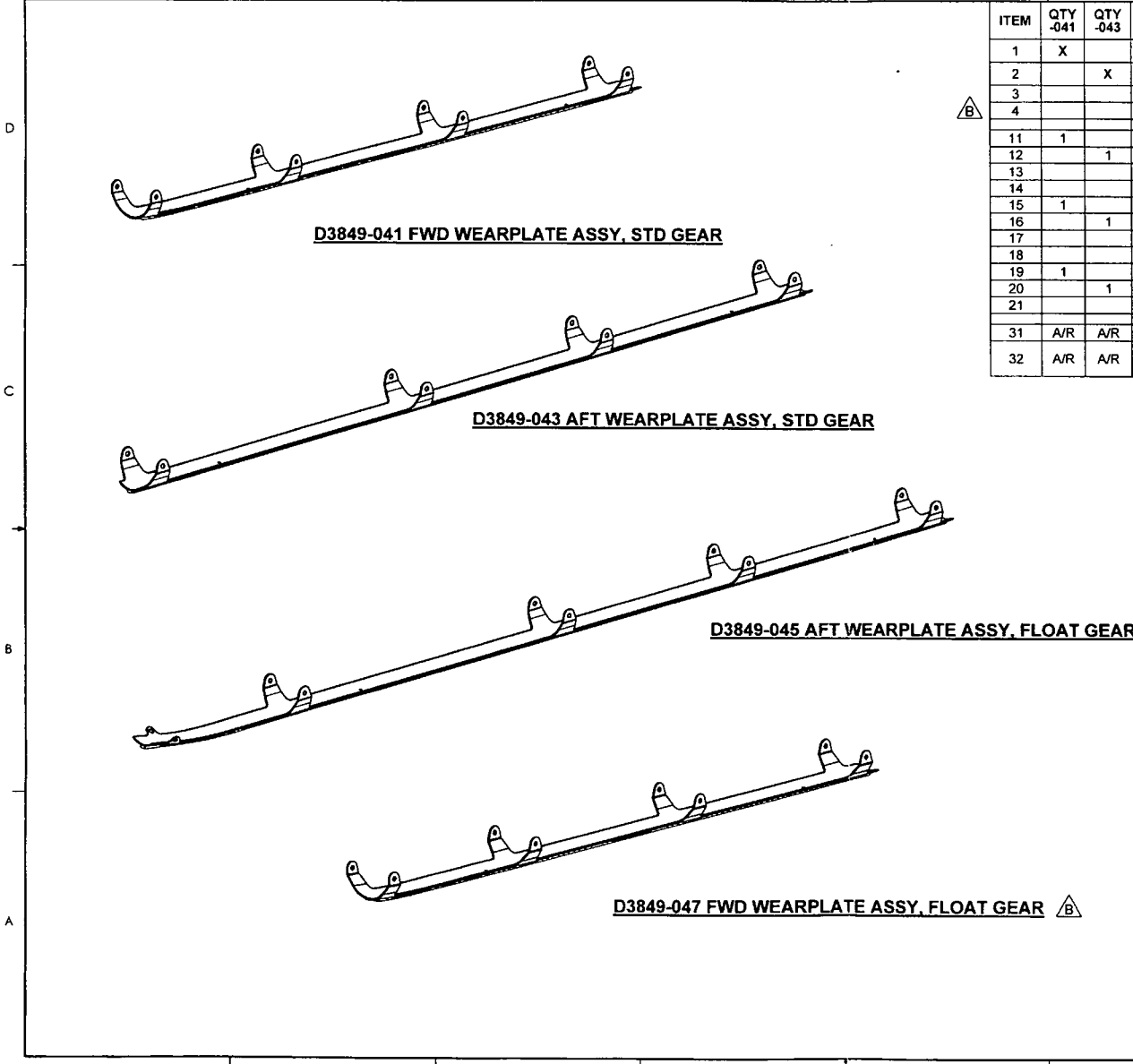
**PRELIMINARY
ISSUE**

**PRELIMINARY
ISSUE** 09.06.16

PRELIMINARY

DESIGN	RF	DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



D3849-041 FWD WEARPLATE ASSY, STD GEAR

D3849-043 AFT WEARPLATE ASSY, STD GEAR

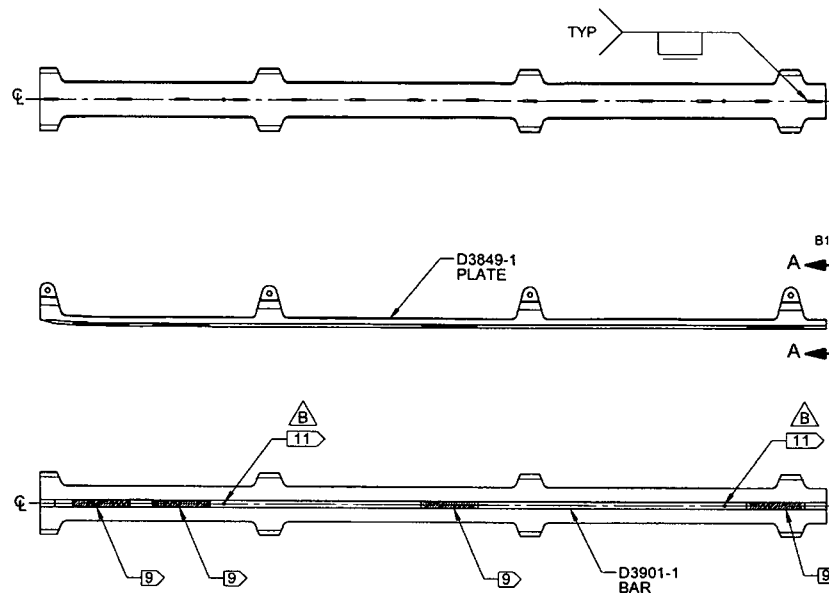
D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR

D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR

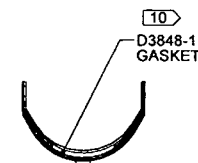
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1				D3848-1	GASKET
16		1			D3848-3	GASKET
17			1		D3848-5	GASKET
18				1	D3848-7	GASKET
19	1			1	D3901-1	BAR
20		1			D3901-3	BAR
21			1		D3901-5	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

B	REVISED FLAT PATTERN Ø0.375 WAS SLOT HOLE ON D3849-1F/3F/5F (ZN A4-5, B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/7F (ZN C4-9, A4-9); ADD SECTION K-K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.44 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4); 66.87 WAS 67.36 (ZN S4-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESIGN	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	PH		
MFG. APPR.	CE		
APPROVED	AW		
DE APPR.	TH		
DATE	09.06.30		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D3849			
TITLE WEARPLATE ASSY			
REV. B SHEET 1 OF 10 SCALE NTS			
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48626
RELEASED
9/6/2014



D3849-041 FWD WEARPLATE ASSY, STD/FLOAT GEAR



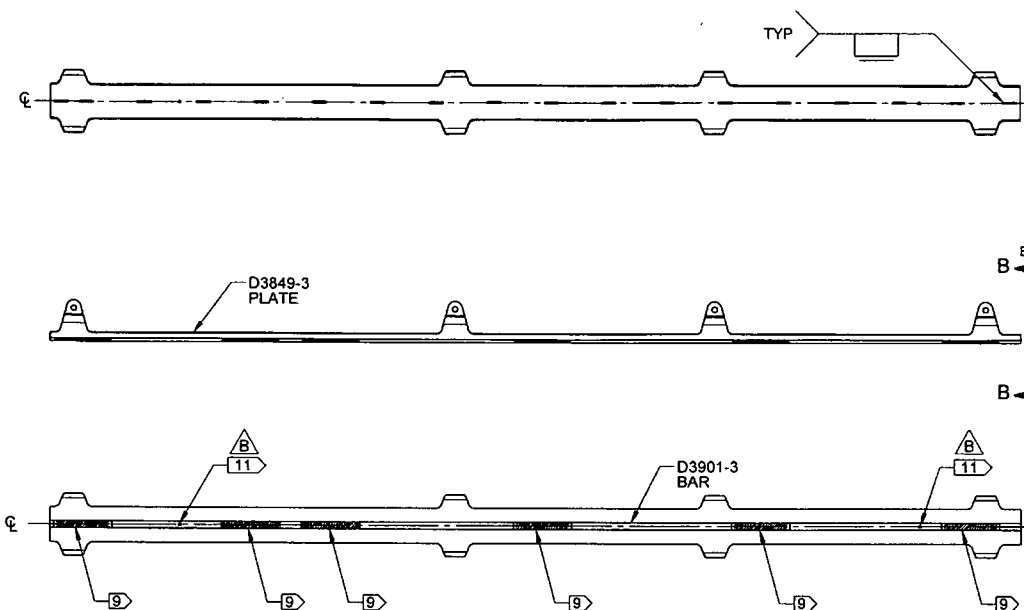
SECTION A-A C3-2
SCALE 2X

RELEASED
19/6/15

NOTES:

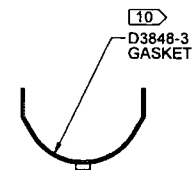
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-041" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-041 = 4.24 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-1 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\phi 0.188$ HOLES FROM D3849-1 PLATE TO D3901-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO. D3849	REV. B
MFG. APPR.		SHEET 2 OF 10	
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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D3849-043 AFT WEARPLATE ASSY, STD GEAR

SECTION B-B C2-3
SCALE 2X



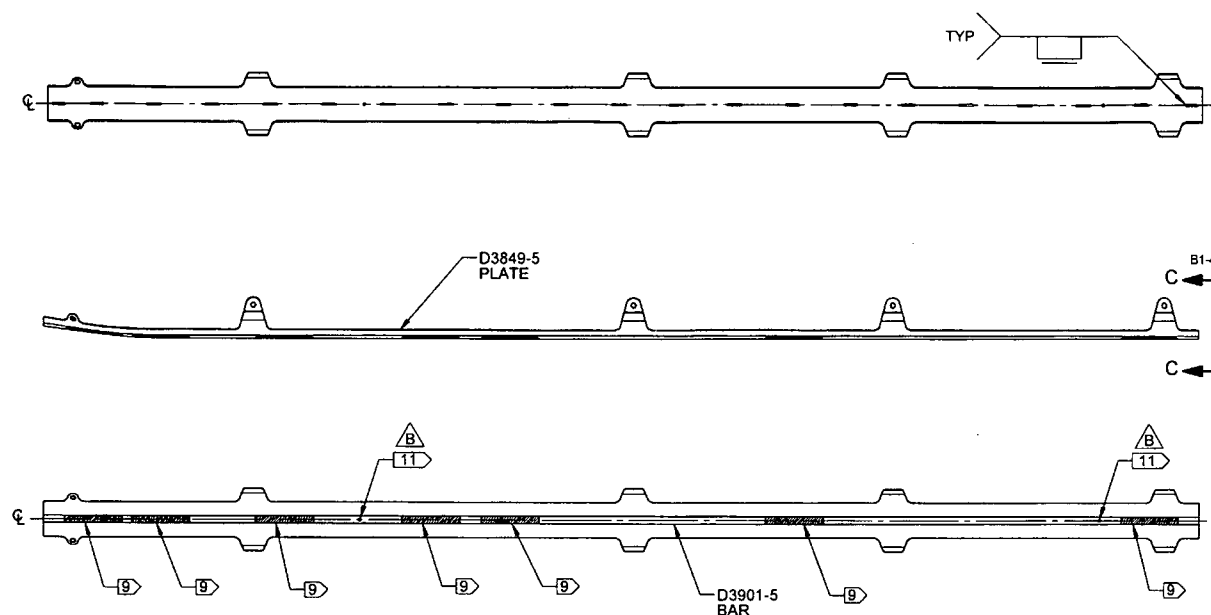
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3849-043 = 5.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-3 PLATE TO D3901-3 BAR

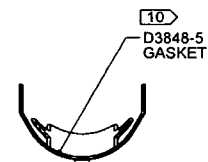
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3849	SHEET 3 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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RELEASED
09/07/15

48626



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



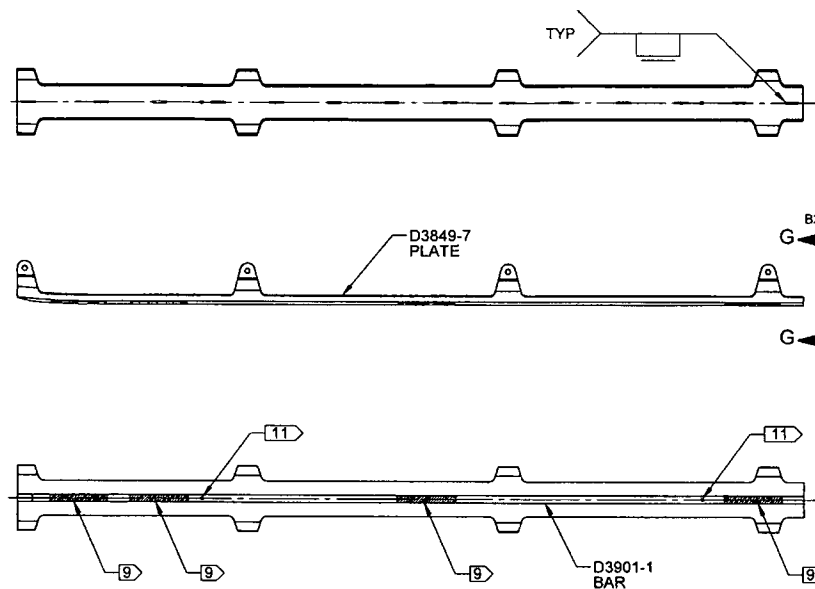
SECTION C-C C2-4
SCALE 2X

RELEASED
09/06/15/ML

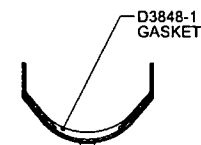
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-045 = 5.98 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-5 PLATE TO D3901-5 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
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MFG. APPR.	RF	D3849	SHEET 4 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR $\triangle B$



SECTION G-G C3-5
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-047" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-047 = 4.26 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-7 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\phi 0.188$ HOLES FROM D3849-7 PLATE TO D3901-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 5 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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RELEASED
9/6/13 MAB

48626

0.3 REF

R38.5

49.51

D3849-1 PLATE
(MAKE FROM D3849-1F)

A6-10

0.050
REF

Δ B
7.72

ϕ 0.188 THRU
2 PL

Δ B
51.313

DETAIL G

C2-10

R0.38
TYP

DETAIL F

A3-10

105°
TYPR0.50
TYP4.00
TYP

C3-10

DETAIL H

Δ B
2.433
TYP

6.642
4 PL

R0.06
2 PL

Δ B
54.26 REF

D3849-1F FLAT PATTERN Δ B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3849	SHEET 6 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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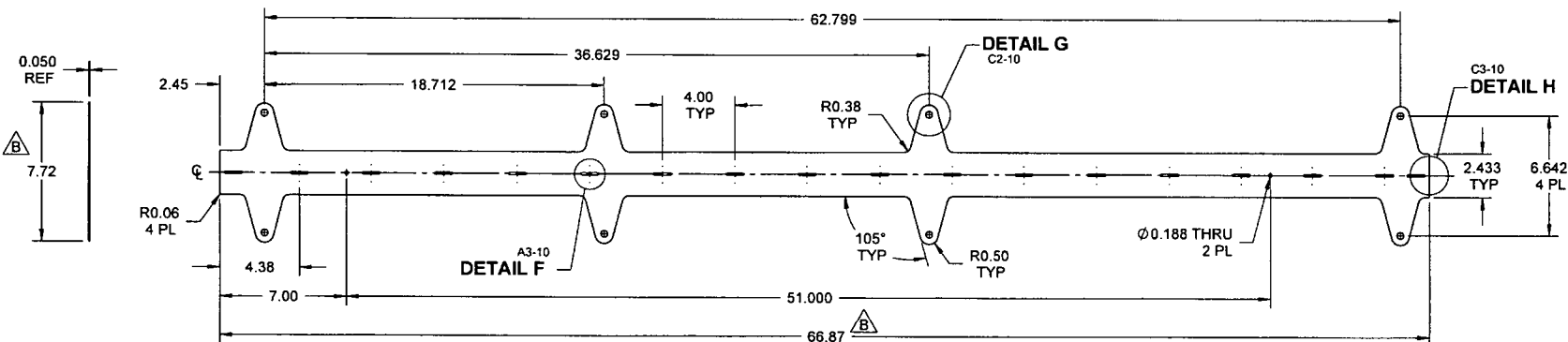
48626

8 7 6 5 4 3 2 1



D3849-3 PLATE
(MAKE FROM D3849-3F)




E
E
A6-10



D3849-3F FLAT PATTERN

NOTES:

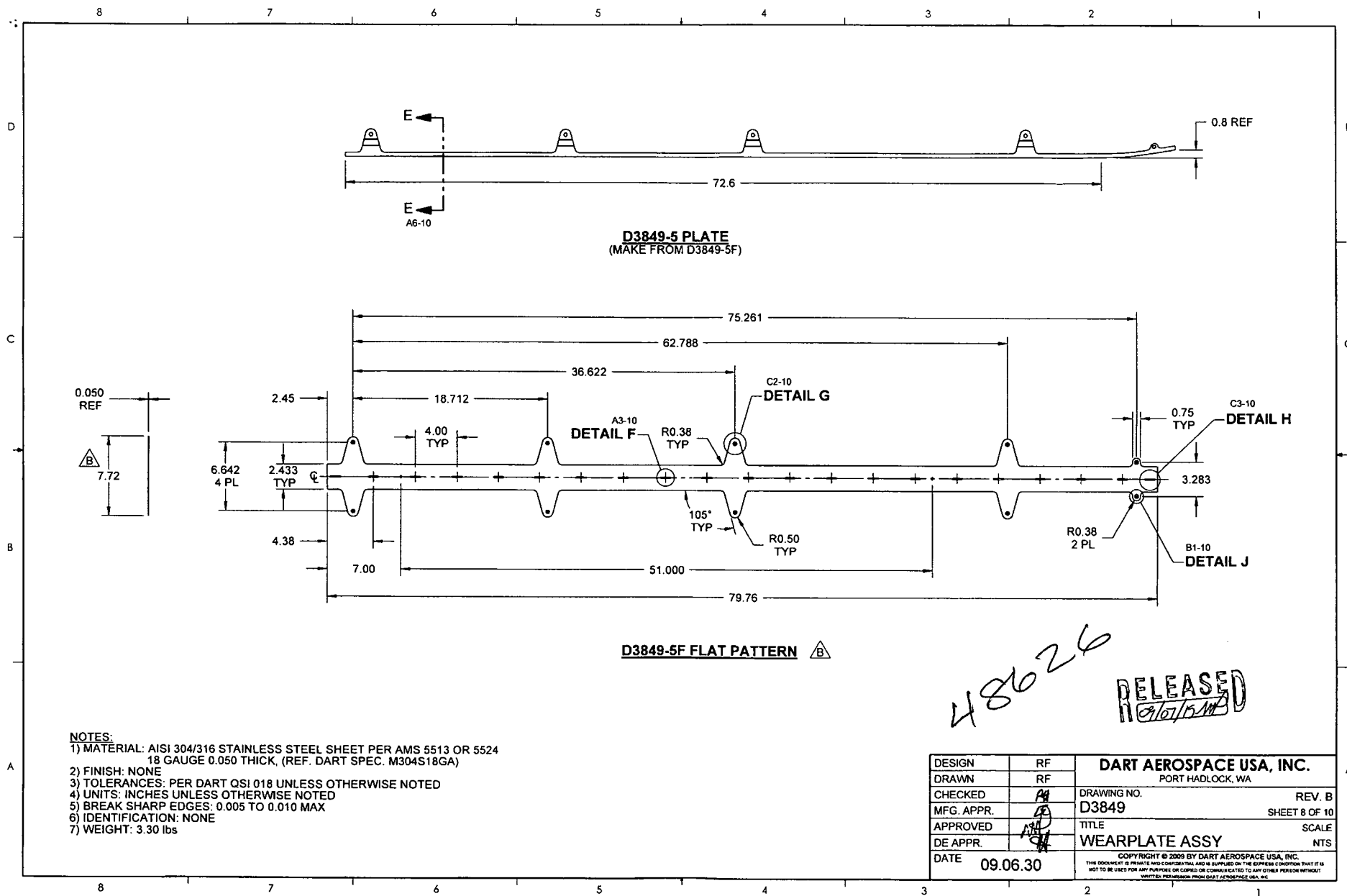
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.82 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 7 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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09/07/15

8 7 6 5 4 3 2 1

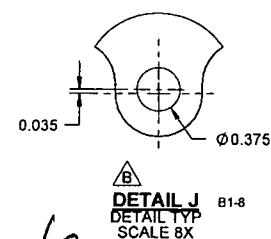
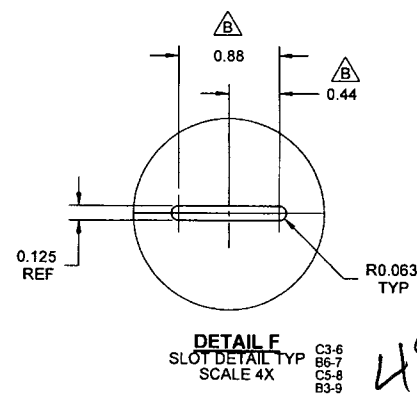
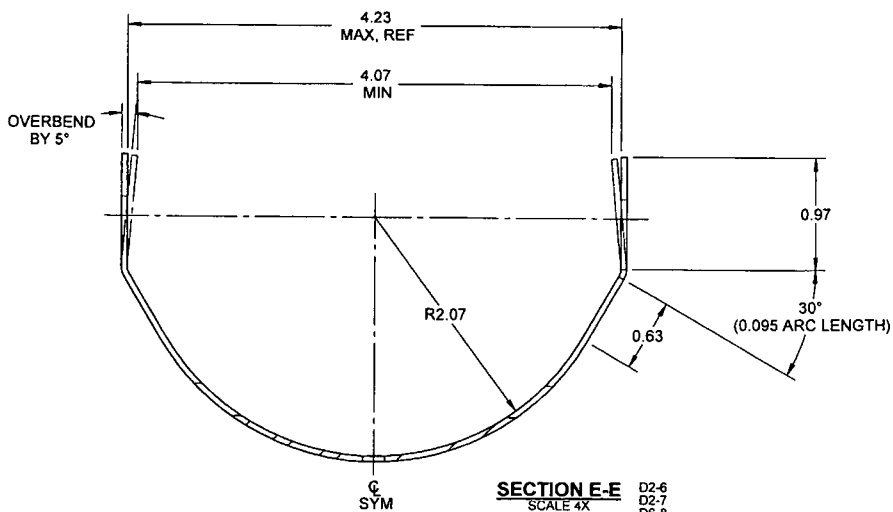
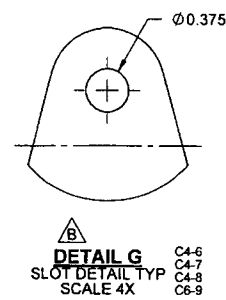
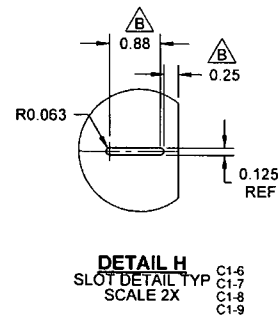
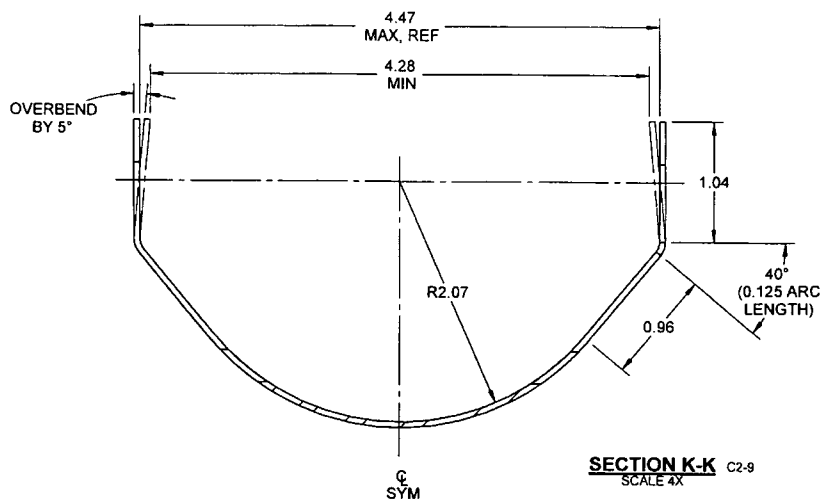






NOTES:

- NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 2.34 lbs.

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 9 OF 10
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